

Date: 6/23/2006 7:38AM  
User: Kim Johnston

**PROCESS SHEET**

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE, OUTBOARD, RH, 206
Job No.	: 27671	Part No.	: D26652
Estimate No.	: 10523	Drawing No.	: D2665 REV. B
P.O. No.	: N/A	Drawing Rev.	: B
First Issue	: N/A	Project No.	: N/A
Prsht Rev.	: NC	Material	: N/A
This Issue	: 6/23/2006	Due Date	: 7/15/2006
Prev. Run	: 25980	QTY:	: 12
Type	: MACHINED PARTS		

Written by:

Checked &amp; Approved by:

Comment :

Est: C 00.11.01 Removed P/O for Powder Coat - in house process EC

Job Number:



Seq. No.	Machine or Operation	Description
1.0	D6101003	7075-T7351 2X6.25X7.875
	Comment:	Qty.: 1.0000 Each(s)/Unit 7075-T7351 2X6.25X7.875 Cut Size 2.0" x 6.25" x 7.88" Total : 12.0000 Each(s) Grain Along Long 7.88 Length <i>D24891</i>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment:	HAAS CNC VERTICAL MACHINING #1 1- Program batch number 2- Machine Step # 1 of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet 4- Machine Step # 3 of Folio and visually inspect as per attached Dimension Sheet 5- Deburr <i>IL 06/06/26</i>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
	Comment:	CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet <i>En 06/07/24 x 12</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment:	INSPECT PARTS AS THEY COME OFF MACHINE <i>JL 06/06/26</i>
5.0	QC8	SECOND CHECK
	Comment:	SECOND CHECK <i>J.G. 06/07/26</i>
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment:	HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 <i>JAD 06/07/26</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: DP Date: 06/07/28

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Job Number:



Seq. No.	Machine or Operation	Description
7.0	POWDER COATING	POWDER COATING
	Comment:	POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 a.m 06-07-25 (12)
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		AP 06/07/27 (12)
	Comment:	INSPECT POWDER COAT
9.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment:	PACKAGING RESOURCE #1 Identify and Stock Location: ST483 AP 06/07/27 (12)
10.0	DC	DOCUMENT CONTROL
	Comment:	DOCUMENT CONTROL Inspection Level 21 D 06/07/28 (12) HJ 06.07.28

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification* Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 27671
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b> D2665-2
<b>Inspection Dwg:</b> D2665 Rev. B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.120	.121	.125	.127		
B	0.100	0.140		.117	.122	.126	.128		
C	0.100	0.140		.119	.122	.126	.126		
D	0.210	0.230		.216	.220	.220	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.249		
G	5.990	6.010		6.000	5.998	5.999	5.998		
H	0.510	0.515		0.515	0.515	0.515	0.515		
I	1.674	1.684		1.678	1.678	1.679	1.679		
J	2.495	2.505		2.491	2.500	2.499	2.499		
K	0.257	0.262	DT8683	✓	✓	✓	✓		
L	0.312	0.317	DT8686	✓	✓	✓	✓		
M	0.235	0.240		0.235	0.237	0.237	0.237		
N	0.100	0.140		.109	.121	.121	.123		
O	0.540	0.560		.549	.548	.547	.545		
P	0.490	0.510		.500	.503	.505	.500		
Q	3.609	3.619		3.614	3.614	3.613	3.614		
R	2.470	2.510		2.500	2.500	2.500	2.500		
S	0.240	0.270		.249	.251	.252	.252		
T	0.100	0.180		.145	.145	.145	.145		
U	0.313	0.318	DT8686	✓	✓	✓	✓		
V	1.125	1.145		1.133	1.134	1.135	1.137		
W	1.565	1.585		1.568	1.574	1.573	1.576		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.L. / Ep
Date: 06/06/25 / 06/07/24

Audited by: J.G.
Date: 06/07/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	#

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 27671
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b> D2665-2
<b>Inspection Dwg:</b> D2665 Rev. B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.124	.122	.122	.120		
B	0.100	0.140		.125	.124	.122	.122		
C	0.100	0.140		.124	.118	.118	.118		
D	0.210	0.230		.221	.219	.220	.219		
E	1.245	1.255		1.250	1.250	1.249	1.250		
F	1.245	1.255		1.249	1.250	1.250	1.249		
G	5.990	6.010		5.998	6.001	5.997	6.006		
H	0.510	0.515		0.515	0.515	0.515	0.515		
I	1.674	1.684		1.678	1.679	1.679	1.679		
J	2.495	2.505		2.500	2.499	2.500	2.499		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		0.237	0.237	0.236	0.236		
N	0.100	0.140		.123	.123	.121	.121		
O	0.540	0.560		.548	.550	.548	.550		
P	0.490	0.510		.502	.501	.500	.499		
Q	3.609	3.619		3.613	3.614	3.614	3.614		
R	2.470	2.510		2.500	2.500	2.500	2.500		
S	0.240	0.270		.252	.251	.252	.253		
T	0.100	0.180		.145	.145	.145	.145		
U	0.313	0.318	DT8686	<del>0.313</del> ✓	/	/	/		
V	1.125	1.145		1.138	1.135	1.135	1.134		
W	1.565	1.585		1.577	1.570	1.574	1.573		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L. / E
Date:	06/06/26 / 06/07/24

Audited by:	J.G.
Date:	06/07/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	#

4925  
5065

4945  
5045

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 27671
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b> D2665-2
<b>Inspection Dwg:</b> D2665 Rev. B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.123	.128	.122	.120		
B	0.100	0.140		.124	.126	.126	.122		
C	0.100	0.140		.119	.121	.119	.119		
D	0.210	0.230		.220	.220	.220	.226		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.249	1.249	1.249	1.249		
G	5.990	6.010		5.995	5.997	5.997	5.998		
H	0.510	0.515		0.515	0.515	0.515	0.515		
I	1.674	1.684		1.679	1.679	1.679	1.675		
J	2.495	2.505		2.498	2.498	2.498	2.498		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		0.236	0.237	0.237	0.235		
N	0.100	0.140		.118	.120	.119	.120		
O	0.540	0.560		.550	.549	.549	.549		
P	0.490	0.510		.501	.499	.499	.497		
Q	3.609	3.619		3.614	3.613	3.613	3.613		
R	2.470	2.510		2.500	2.500	2.500	2.500		
S	0.240	0.270		.253	.258	.259	.256		
T	0.100	0.180		.145	.145	.145	.145		
U	0.313	0.318	DT8686	/	/	/	/		
V	1.125	1.145		1.131	1.132	1.131	1.1345		
W	1.565	1.585		1.570	1.570	1.570	1.574		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject				Final 10/1/14					

Measured by: J.L. / SA	Audited by: J.G.
Date: 06/06/2014 / 06.06.27	Date: 06/07/2014

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	#

5A-2

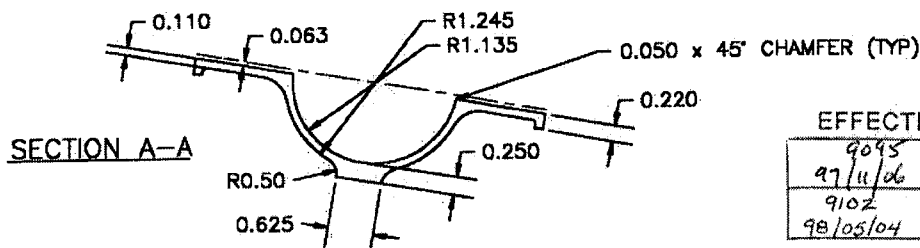
5B-2



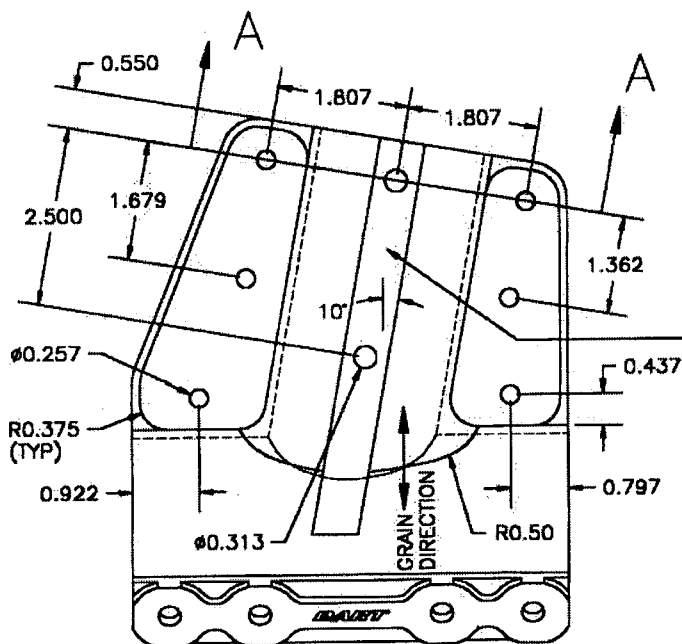
**DART**



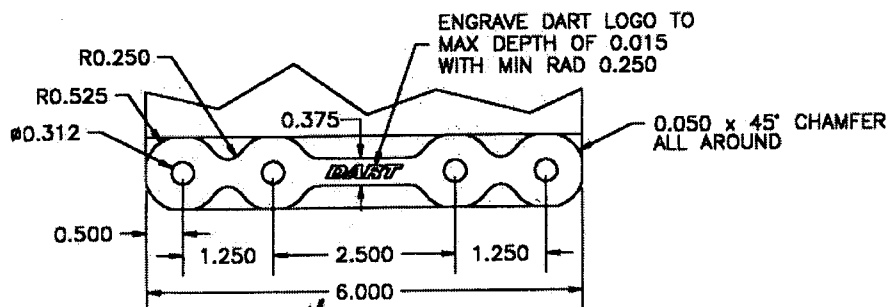
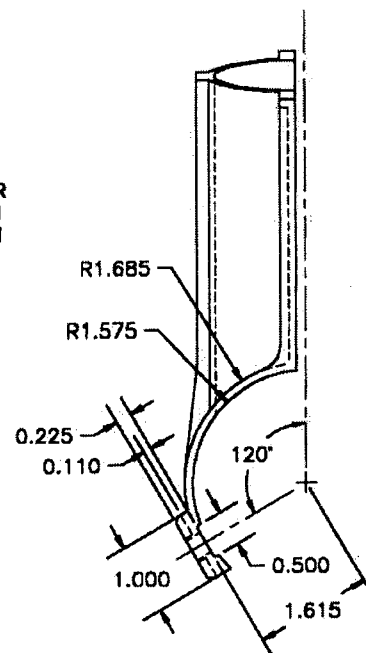
DESIGN <i>DMX</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DMX</i>	APPROVED <i>KE</i>	DRAWING NO. D2665	REV. B SHEET 1 OF 1
DATE 97.07.11	TITLE SADDLE FWD OUTSIDE HIGH	SCALE 2:5	
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	



EFFECTIVE	DEOs
9045 97/11/06 DS	9122 98/12/14
9102 98/05/04 DS	



ENGRAVE PART  
NUMBER AND  
BATCH NUMBER  
TO MAX DEPTH  
OF 0.010 WITH  
MIN RADIUS  
OF 0.010



MATERIAL: ~~7075-T651~~ OR 7075-T7351 (QQ-A-250/12)  
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
 PRIME, PAINT (EXCEPT BORES) PER DART QSI 005 4.2  
 NOTE: D2665-1 SHOWN (D2665-2 IS OPPOSITE)  
 BREAK ALL SHARP EDGES 0.010 TO 0.020  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**  
 97/07/16 DS  
 ECN 008

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 WORK ORDER  
 NO. 27671